QC

Quality Control

April-12-13 8:13:22 AM Item ID: D2236 Accept *N900040100* Setup Start **Revision ID:** Item Name: Lid Rib **Start Date:** 4/19/13 Start Qty: 4.00 Cust Item ID: Required Date: 4/19/13 • Req'd Qty: 4.00 **Customer:** Reference: Run Process Plan: MC5 Date: 13-04-17 Tooling: **Approvals:** Date: Stop Date: _____ SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Reject Accept Reject Insp. **Work Center ID** Description **Run Hours** Qty Number Stamp Code Qty Draw Nbr **Revision Nbr** D2236 C 0.00 Large Fab *100* Large Fab 0.00 Memo Large Fab 1- Pick D3166-3 and cut use DT8303 2- Remove identification markings on tube 3- Deburr 110 QC6- Inspect dimensions to drawing *110*

0.00

Memo

			WORK ORDER MOIN-	COI	VEORIN	IANCE / UPDATE		QA Closed:	Date	:
			DISPOSITION	·		AGAINST		PARTMENT/	PROCESS	
			Rework Scrap Use-as-is Work Order Update		Skid-tube Crosstube Machining Small Fab Thermoforming Finishing Large Fab Composite				Water Jet d. Eng. Coor. e/Packaging Supplier	Engineering Quality Other
Date Step	Otv		•	1	1	Action Description		Sign & Date	Verification	QC Inspector
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			F	AUL	T CATE	ORY				
acks ushed/Crimped iffs eat Treat spection Strip i pples in Bend	ed. in Tube	,	General Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes		Inspecti Instructi Mainte Mislabe Misread Offset	on Incomplete ons Incomplete/Unclear nance led		Over/Under Part Incorred Part Lost/Mi Part Moved Positioned V	et ssing Vrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other
	r nding ntre Not Cond acks ushed/Crimpe ffs at Treat spection Strip oples in Bend	r nding ntre Not Concentric to e acks ushed/Crimped. ffs at Treat pection Strip in Tube oples in Bend	r nding ntre Not Concentric to O/S acks ushed/Crimped. ffs at Treat pection Strip in Tube	Description of work order update or Non-conformance To act	Description of work order update or Non-conformance FAUI General Bend BoM/Route Broken/Damaged Burrs Contamination Countersink Description of work order update or Non-conformance Ch	PAULT CATEOR To a Step Qty Or Non-conformance Chief Eng PAULT CATEOR General Bend Grain Bend Grain Body/Route Broken/Damaged Instruction Burrs Instruction Burrs Instruction Burrs Instruction Gountersink Mainte Description of work order update Initial Chief Eng FAULT CATEOR General Grain Hardwar Hardwar Inspection Mainte Countersink Mislabel Optes in Bend Drill Holes Offset	FAULT CATEGORY r General nding ntre Not Concentric to O/S acks ashed/Crimped. Broken/Damaged Burrs Burrs Contamination Burrs Contamination Burrs Contamination Chief Eng Description FAULT CATEGORY Grain Hardware Inspection Incomplete Instructions Incomplete Instructions Incomplete Instructions Incomplete Maintenance Maintenance Mislabeled Description FAULT CATEGORY FIGURE 1 Action Description FAULT CATEGORY FAULT CATEGO	FAULT CATEGORY r General Inding Intre Not Concentric to O/S Isshed/Crimped. Intre Not Concentric to O/S Isshe	Date Step Qty Description of work order update Chief Eng Description Date FAULT CATEGORY T General Inding India Indi	Date Step Qty Or Non-conformance Chief Eng Description Date Verification FAULT CATEGORY FAUL

Out of Sequence

Outside Dimensions

DQA:

Date:

Turning Sequence

Wave/Twist in Tube

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Quality Control

99847

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April-12-13 8:13:22 AM D2236 Item ID: Accept *N900040100* Setup Start **Revision ID:** Item Name: Lid Rib **Start Date:** 4/19/13 Start Qty: 4.00 **Cust Item ID:** Required Date: 4/19/13 Req'd Qty: 4.00 **Customer:** Reference: Run Process Plan: _____ Date: **Approvals:** Tooling: Date: Stop QC: _____ Date:___ SPC (Y/N): Date: Sequence ID/ **Operation** Set Up/ Tool ID Tool # Plan Reject Accept Reject Insp. **Work Center ID** Description **Run Hours** Code Qty Qty Number Stamp 120 Identify as per dwg & Stock Location: 0.00 *120* Packaging 0.00 Memo Packaging 130 QC21- Final Inspection - Work Order Release 0.00 *130* MCJ 13-06-05 QC 0.00 Memo

NB-dr5

											DQA:	Date:		
NCR: Y	es / No				WORK OR	DER NON-C	ONFOR	MANCE / UF	PDATE		QA Closed:	Date:		
					DISPO	SITION		AGAINST DEPARTMENT/PROCESS						
Part NoNCR No					Work Ord	Rework Scrap Use-as-is er Update		Skid-tube Crosstube Machining Small Fab Thermoforming Finishing Large Fab Composite				Water Jet d. Eng. Coor. e/Packaging Supplier	Engineering Quality Other	
Root	· · · · · · · · · · · · · · · · · · ·	T		Descri	ption of work or	der update	Initial	А	ction		Sign &			
Cause	Date	Step	Qty		or Non-conform		Chief Eng		cription		Date	Verification	QC Inspector	
Doc/Data Equip/Tooling		ССР					<u>.</u>							
Operator Material					V				•		,	·		
Setup Other				,		•								
Process											. *			
Supplier Training			ļ											
Unapproved			-	:					_					
				•		F/	AULT CATE	GORY						
Landi	ng Gear				Gener	al					I		7	
	Bending			<u></u>	Bend		Grain				Ovalized		Pressure/Forced	
	Centre N	ot Conce	ntric to	o/s	BOM/Route		Hardwa			-	Over/Under		Temperature/Cure	
	Cracks			-	Broken/Damag	ged	⊢	ion Incomplete			Part Incorre	<u> </u>	Weld	
	Crushed/Crimped.			<u> </u>	Burrs		⊢	tions Incomplete	e/Unclear	-	Part Lost/M Part Moved	issing	Wrong Stock Pulled	
	Cuffs	_*		-	Contamination		Mislabe	enance		-	Part Moved Positioned \	Mrong		
	Heat Trea		Tubo	-	Countersink Cut Too Short		Misrea			<u> </u>	Power Loss/		Other	
	Inspection Ripples in		iube	-	Drill Holes		Offset	u		<u> </u>	1. 5 4 61 2033/			
-	_	Vaves in I	Extrusio	, <u> </u>	Drawing .			Calibration						
	— 'S'43C '			··			H							

Out of Sequence

Outside Dimensions

Turning Sequence Wave/Twist in Tube Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

April-12-13 8:13:25 AM

Work Order ID: 99847

D2236

Parent Item Name: Lid Rib

Start Date: 4/19/13

Required Date: 4/19/13

Start Qty: 4.00

Required Qty: 4.00

Comments:

Parent Item:

IPP REV:A 12.11.28 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3166-3		Manufactured	No			100	Each	1.0387	0.25	1			
D3166-3									**	(8x) C	00 1	3.5.5	31

-				
Location	<u>1</u>	Loc Qty	Loc Code	
WA .		0.494736	B98074>	<i>(8,309)</i>
.,	94157	0.494736	10 / - 0 / /	
WA004		0.1052		
	81578	0.1052		
WA007		0.4388		
	77294	0.4388		

DQA: Date: **WORK ORDER NON-CONFORMANCE / UPDATE** NCR: Yes / No QA Closed: Date: AGAINST DEPARTMENT/PROCESS DISPOSITION Work Order: Engineering Crosstube Water Jet Skid-tube Rework Small Fab Prod. Eng. Coor. Quality Machining Scrap Part No. Finishing Rec/Store/Packaging Other Thermoforming Use-as-is Large Fab Composite Supplier Work Order Update NCR No. Description of work order update Initial Action Sign & Root Verification QC Inspector or Non-conformance Chief Eng Description Date Step Qty Date Cause Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved **FAULT CATEGORY Landing Gear** General Pressure/Forced Grain Ovalized Bend Bending BOM/Route Over/Under tolerance Temperature/Cure Hardware Centre Not Concentric to O/S Weld Broken/Damaged Inspection Incomplete Part Incorrect Cracks Wrong Stock Pulled Instructions Incomplete/Unclear Part Lost/Missing Crushed/Crimped. Burrs Maintenance Part Moved Cuffs Contamination Mislabeled Positioned Wrong Countersink Heat Treat Other Misread Power Loss/Surge Inspection Strip in Tube Cut Too Short

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Drill Holes

Drawing

Finish

Folio

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Torque Waves in Extrusion

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G



DESIG E	BW N	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECH	KED #	APPROVED	00076	EV. C OF 1
DATE			TITLE S	CALE
05.0	06.07		LID RIB	1:4
Α	·	94.05.30	NEW ISSUE	
В		94.12.16	LID	
С	-	05.06.07	UPDATE NOTES, CHANGE RADIUS TO 19	9.0

		:
÷.7(REF)		
	R19.0 (REF)	
	25.50 —	

D2236 LID RIB

- MAKE FROM D3166-3 BASKET HOOP

 FINISH: NONE

 ALL DIMENSIONS ARE IN INCHES

 ALL TOLERANCES AER PER DART QSI 018 UNLESS OTHERWISE NOTED

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